

Work Order ID 81827

81827

Page 1

Monday, March 19, 2012 4:04:37 PM

Item ID: D135-692-011 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bearpaw
 Start Date: 3/19/2012 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 3/21/2012 Req'd Qty: 4.00 ***4*** Customer:
 Reference: ECN12-550 - *Rework*

Approvals: Process Plan: *mf* Date: *12-03-19* Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3049	Rev A1

190 0.00

190

Packaging

Memo

0.00

Packaging

PULL FROM STOCK D135-692-011 X 4 B78385

REMOVE AN4-15A B120187 X 8 PER KIT AND RETURN TO STOCK
 UNDER ORIGINAL BATCH NUMBER

M119749

REPLACE WITH AN4-13A X 8 B _____ PER KIT
 PER ECN 12-550 (DSI 9587)

REMOVE 4 X D2519 B _____ PER KIT AND RETURN TO STOCK UNDER
 ORINAL BATCH NUMBER
 PER ECN 12-550 (DSI 9592)

12/3/00 54 (4)

200

QC4- 100% Inspect kits for completeness

0.00

200

QC

Memo

0.00

8/26/03/27

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 81827

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Monday, March 19, 2012 4:04:37 PM

Item ID: D135-692-011

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Bearpaw

Stop ***NS2***

Start Date: 3/19/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 3/21/2012 Req'd Qty: 4.00

4

Customer:

Reference: ECN12-550

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210	Identify as per dwg & Stock Location: <u>11A</u>	0.00							
210									
Packaging	Memo	0.00							
Packaging	ID AND STOCK UNDER NEW BATCH NUMBER								
	ADD NEW DSI'S TO PAPERWORK								
220	QC21- Final Inspection - Work Order Release	0.00							
220									
QC	Memo	0.00							
Quality Control									

leuc

CA G002

HJB MLJ 12-3-23 (4)

12/3/27

5/4

12/3/28

12/03-27

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 81827

Parent Item: D135-692-011

Parent Item Name: Bearpaw

Start Date: 3/19/2012

Required Date: 3/21/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:C04.02.17Blank size changed, Tolerance added Step 3KJ/JLM
IPP Rev:D 08-04-16 Added Step 2 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN4-13A Bolt		Purchased	No				Each	1,357.0000		32			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST357				1357					
				119449				59					
				<u>120187</u>				398		32			
				<u>120422</u>				500					
				120770				400					
AN4-15A Bolt		Purchased	No				Each	359.0000		32			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				GA				100					
				120449				100					
				ST358				259					
				118706				15					
				<u>120187</u>				44		32			
				<u>120422</u>				200					
D2519 Clamp		Manufactured	No				Each	28.0000					
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST459				28					
				<u>73499</u>				28					

50

32

50

32

12/31/22

50 (4)

10

157

1x 65118

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D135-692 REV. A AND
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D135-692 REV. 0
REF. FAA STC: SR01042SE

PURPOSE:

The purpose of this service instruction is to replace the AN4-15A Bolt with a shorter AN4-13A Bolt to facilitate installation.

CHANGE:

5. PARTS LIST (IIN-D135-692)
32.4 PARTS LIST (ICA-D135-692)

Qty	Part Number	Description
X	D135-692-011	BEARPAW INSTALLATION

IS:

8	AN4-13A	BOLT
---	---------	------

WAS:

8	AN4-15A	BOLT
---	---------	------

Figure 2 of IIN-D135-692 and Figure 32-2 of ICA-D135-692 are amended as follows:

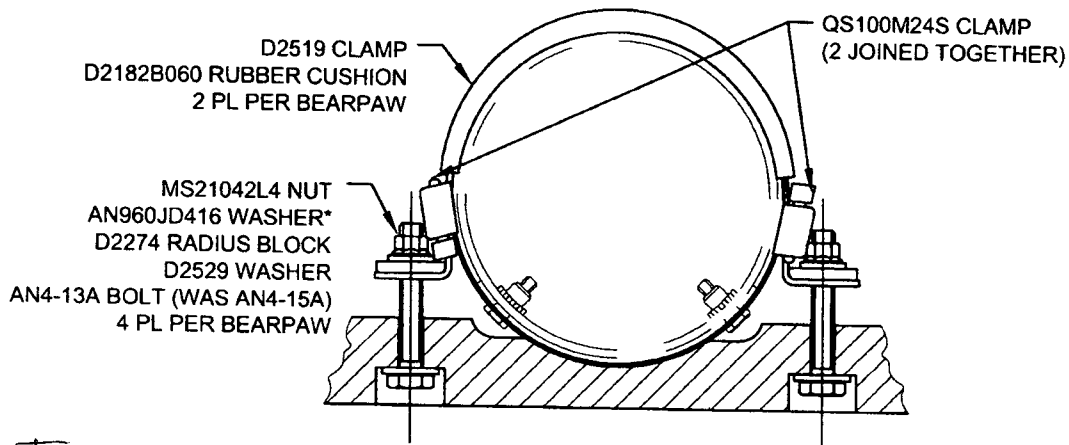


Figure 2 - Bearpaw Installation (IIN-D135-692)
Figure 32-2: Bearpaw Installation (ICA-D135-692)

LCS18A

A	NEW ISSUE	(REF: PAR10-56)	MB	11.12.13
REV.	DESCRIPTION		BY	DATE
DESIGN		DART AEROSPACE USA, INC KENT, WA		
DRAWN				
CHECKED		DRAWING NO.	REV. A	
MFG. APPR.	N/A	DSI 9587	SHEET 1 OF 1	
APPROVED		TITLE	SCALE	
DE APPR.		BOLT CHANGE	NTS	
DATE	11.12.13	COPYRIGHT © 2011 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.		

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART SERVICE INSTRUCTION

TO AMEND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D135-692 REV. 0

REF. FAA STC: SR01042SE

REF. TCCA LETTER OF ACCEPTANCE: 120S-GA-08-52

REF. UK STC: AAN #28700

PURPOSE:

THE PURPOSE OF THIS SERVICE INSTRUCTION IS TO CORRECT A DISCREPANCY IN SECTION 32.4 OF ICA-D135-692 REV. 0.

CHANGE:

FOR D135-692-011 BEARPAW INSTALLATION, THE D2519 CLAMP QTY(8) SHOWN IN THE PARTS LISTS IS UPDATED AS INDICATED BELOW:

32.4 PARTS LIST

Qty	Part Number	Description
X	D135-692-011	BEARPAW INSTALLATION

IS:

4	D2519	CLAMP
---	-------	-------

WAS:

8	D2519	CLAMP
---	-------	-------

12827

A	NEW ISSUE	(REF CAR11-60)	MB	12.01.18
REV.		DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE USA, INC KENT, WA		
DRAWN				
CHECKED		DRAWING NO.	REV. A	
MFG. APPR.	N/A	DSI 9592	SHEET 1 OF 1	
APPROVED		TITLE	SCALE	
DE APPR.		PARTS LIST CORRECTION	NTS	
DATE	12.01.18	COPYRIGHT © 2012 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January-09-12 8:51:36 AM

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Work Order ID: 78385

78385

Parent Item: D135-692-011

D135-692-011

Parent Item Name: Bearpaw

Start Date: 09/01/2012

Required Date: 23/01/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:C04.02.17Blank size changed, Tolerance added Step 3KJ/JLM
IPP Rev:D 08-04-16 Added Step 2 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN4-15A

Purchased

No

160

Each

21.0000

8

32

AN4-15A

Bolt

**

Location

Loc Qty

Loc Code

ST358

21

118648

4

118706

17

AN960JD416

NAS1149D0463J

Purchased

No

160

Each

0.0000

8

32

AN960JD416

Washer

D2182B

Manufactured

No

160

f

530.8342

2

8

D2182B

Rubber Cushion

**

Location

Loc Qty

Loc Code

ST410

530.83417

66063

53.94817

73932

476.886

(D2182B060) Cut 4 at 6.00"

D2274

Manufactured

No

160

Each

149.0000

8

32

D2274

Radius Block

**

Location

Loc Qty

Loc Code

ST007

149

73389

1

76104

66

77034

82

REFERENCE ONLY

m/20187 SP

m/119075 SP

SP

SP

B78589 32x

SP 12-02-28

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January-09-12 8:51:36 AM

Page 2

Work Order ID: 78385

78385

Parent Item: D135-692-011

D135-692-011

Parent Item Name: Bearpaw

Start Date: 09/01/2012

Required Date: 23/01/2012

Start Qty: 4.00

Required Qty: 4.00

D2519

Manufactured No

160

Each

52.0000

4

16

D2519

Clamp

**

SP.

Location

Loc Qty

Loc Code

ST459

52

65118

1

73499

51

15x

32

B79221 SP.

D2529

Manufactured No

160

Each

166.0000

8

D2529

Washer

**

Location

Loc Qty

Loc Code

ST010

166

76086

166

8

B78386 ex SP.

D3049-1

Manufactured No

160

Each

0.0000

2

D3049-1

Bearpaw

**

MS21042L4

Purchased No

160

Each

8,007.000

8

32

MS21042L4

Nut

**

SP

Location

Loc Qty

Loc Code

ST300

8007

117441

51

117601

342

118451

133

119017

2481

119075

5000

32x

January-09-12 8:51:36 AM

Shop Packet Print

Page 2

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ENGINEERING CHANGE NOTICE

DART AEROSPACE LTD

Date: 12.03.16	Job No.:	ADR Yes/No: Y	ADR Date: 11.03.15	ECN #: 12- 550
Product No.: D135-692		Created By: CP	Approved By: <i>[Signature]</i>	
Product Name: Bearpaw		Checked By: <i>[Signature]</i>		

Distribution	Reqd	Resp	Initial / Date
Production Manager / Coord.	Y	LL	
Purchasing Coord.	N		
Production Engineering Coord.	Y	EC/DD	

Distribution	Reqd	Resp	Initial / Date
DQA / QA Coord.	N		
QC Coordinator	<i>[initials]</i> Y	ED.	
Customer Technical Support	Y	MB	
Marketing	Y	SW	
Customer Order Processing	N		

Reason for Change:

Documents Affected:

Release
 DSI 9537 Rev. B
 DSI 9587 Rev. A
 DSI 9592 Rev. A

PARTS MUST COMPLY



PREVIOUS PARTS SATISFACTORY



#	Quality Assurance Actions	Reqd	Resp	Notes	Complete
1	Notify Previous Customers	N			
2	Notify Eurocopter France	N			
3					

#	Engineering Actions	Reqd	Resp	Notes	Complete
4	Required Documents/Drawings Under Review	N			
5	Update Master Document List (MDL)	Y	MB		
6	Update Product Compatability Matrix	N			
7	Create Eurocopter Form (FEE)	N			
8	Notify TC / FAA of Change	Y	CP		
9					12.03.19 <i>[initials]</i>

#	Document Control Actions	Reqd	Resp	Notes	Complete
10	Move Electronic Files/Design Journal	Y	KJ		12.03.19 <i>[initials]</i>
11	Update Product Specification Files	Y	KJ		12.03.19 <i>[initials]</i>
12	Update Approved/Preliminary Dwg PDF Files	Y	KJ		12.03.19 <i>[initials]</i>
13	Update Document Record (DR)	N			
14	Update Product Development Summary	N			
15	Update QSI 021 and/or STC Approval List	N			
16	Update Parts / STC Database	N			
17	Update / Verify ARC Database	N			
18	Create / Update Change Record Form / Item Card Database	N			
19	Create / Update PPP's	N			
20	Red Decals required?	N			
21	Update Document Control Database / Laminated Dwgs	N			
22	Update Grey Project / Electronic Binder PDF Files	Y	KJ		12.03.19 <i>[initials]</i>
23	Update D-Part/M-Drawing/DSI/DEO Master Binders	Y	KJ		12.03.19 <i>[initials]</i>
24					

Description / Action:

- Per DSI 9592, there should only be (4) D2519 Clamps in a D135-692-011 kit
- Per DSI 9587, replace (8) AN4-15A with (8) AN4-13A bolts in D135-692-011, update kits in stock
- add DSI's to kits in stock

*6 Kits in stock:
 2 x 73966 : Rework #81826
 4 x 78385 : Rework #81827*

ECN Verified & Complete: _____

Date: _____